



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4278-047
Job Sheet 178686



Part No: D4278-047

Job Qty: 4 ea

Part Name: Upper Rib Assembly-Straight



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/6/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4278 REV C SHEET 4, D4277 REV D SHEETS 1,2 IPP Rev:A 10.11.12 new issue DD ver:EC IPP
Rev:B 11.01.20 AS PER DWG REV.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		6/15/18	0.00	0.00	Start Up Large Fab-6		SC 2018-06-07
100	Large Fab	4 pcs		6/15/18	0.00	5.19	Large Fab 1		OK 1806/14
110	QC	4 pcs		6/15/18	0.00	0.00	QC10		38 DAS
120	QC	4 pcs		6/15/18	0.00	0.00	QC5		9-80 38
130	Packaging	4 pcs		6/15/18	0.00	0.00	Packaging3 Large Fab		SC 2018-06-15
140	QC21-SA	4 Ea		6/15/18	0.00	0.00	QC21		21 180618

Part Op 100 - 1- Cut D4277-1 tube as per dwg D4277 2- Drill and chamfer holes on both side using DT9718-30 Remove marking
Descriptions: 4-Deburr 5- Assemble bushing and weld as per dwg 6- Grind weld flush as per dwg
130 - ***STOCK IN BASKET CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-9	Bushing	16 Ea (4 ea)	90-Start up Operation	5072143 (4) 5077600 (12)
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	8.3200 ft (2.08 ea)	90-Start up Operation	5046503

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-9	16	64	0
	M304TS0.750W.049	8	1,025	0

Part Specifications

not be found.

Plex 6/6/18 9:43 AM Dart.lajeunesse.marie



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Container No: S078860



Part: D4278-047

Job No: 178686

Serial No/Batch: S078860

Revision:

Inspector:

Exp Date: 06/07/2018

Instructions:

Date: 06/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								